

Work Order ID 73222



Page 1

Friday, August 26, 2011 10:26:31 AM

Item ID: D3239-1

Accept



Setup Start



Revision ID:

Item Name: Cover

Stop



Start Date: 8/26/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: CLDate: 11/08/26 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3239	Rev A

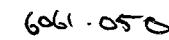
100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet



Memo

1-Cut as per Dwg D3239 Dwg Rev: A Prog Rev: A 2-
Deburr if necessaryB 4-8-3115

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

B 11-8-31

120



QC8- Inspect parts - second check

QC

Quality Control

Memo

0.00

Sumay(3)115

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73222

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Item Name: Cover

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Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Memo

0.00
145

140



Chemical Conversion Coat per QSI005 4.1

0.00

15 BL 11-9-1

HandFinish

Memo

0.00

150



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

15X SM, 11/09/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start



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Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
Description

160

Identify as per dwg & Stock Location: ST 44

Packaging

Packaging

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

(Sx)

SP 11-09-01

C

170



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

11/9/08

MF
11-09-01

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, August 26, 2011 10:26:29 AM

Work Order ID: 73222



Parent Item: D3239-1



Parent Item Name: Cover

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: A New Issue 05-11-06 JLM
IPP: b 06.11.15 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased		No		100	sf	158.4000	0.18	1.894737	3,		

6061-T6 .050 Sheet



Location	Loc Qty	Loc Code
MAT021	158.4	
113216	19	
114799	107.4	
114993	32	

1811-8-31

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

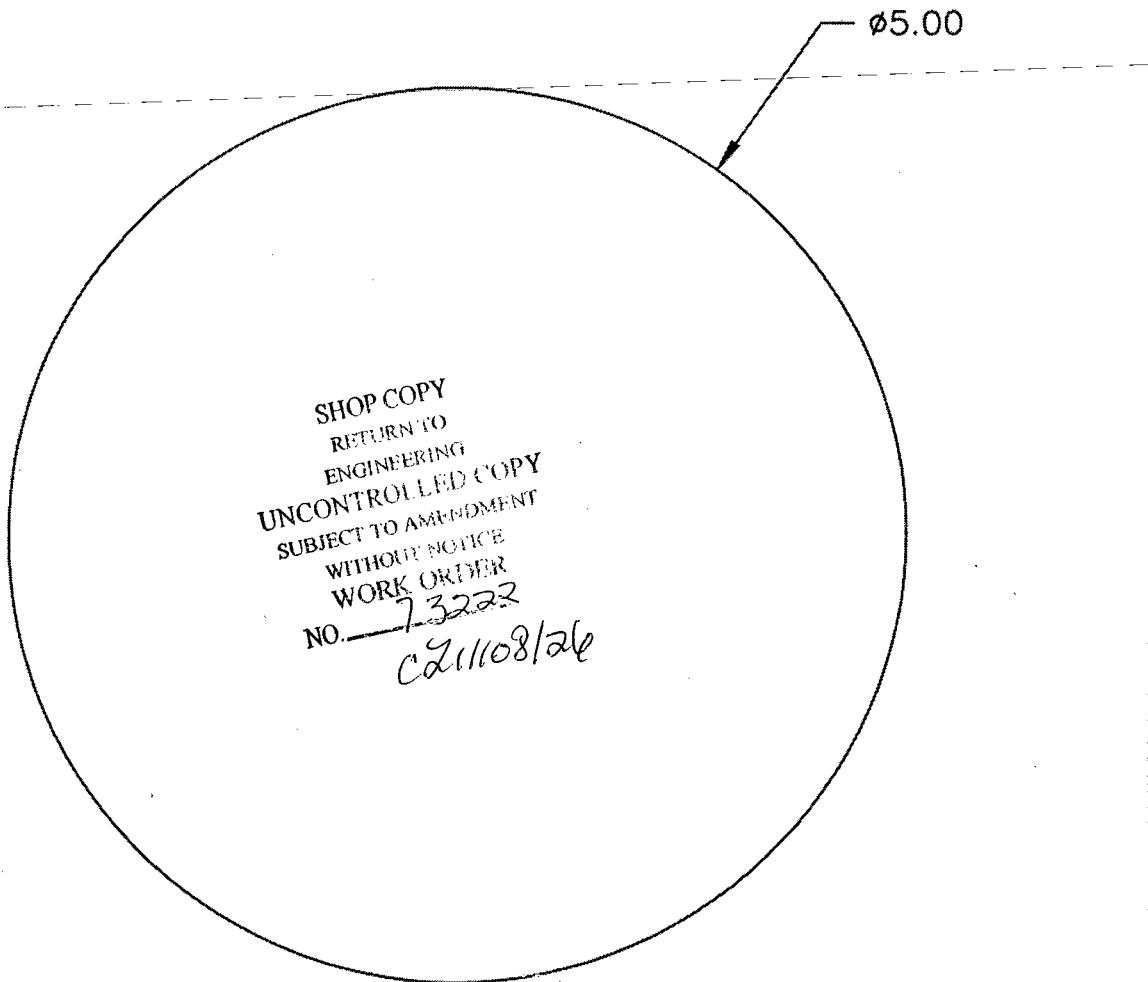
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. A D3239
DATE		TITLE SHEET 1 OF 1 03.12.19 COVER
A	03.12.19	SCALE 1:1 NEW ISSUE

RELEASED
04.02.03



D3239-1 COVER

- 1) MATERIAL: 6061-T6 (QQ-A-250/11), 0.050 THICK (REF. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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DART AEROSPACE LTD	Work Order:	73222
Description: Cover	Part Number:	D3239-1
Inspection Dwg: D3239	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>RB</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>11-8-31</u>	Date: <u>11/08/31</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.10.05	New Issue	P/O D412-709-011	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>